NCR:	(Yes)	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA Date	17/10/11	¢
DUAL ALM L Date	:: <u>)[03] []</u>	
1	, , ,	
-1/2	2/2/7	

_									QA Closea:	OW Date:	
Work Ordei	r:9	618	4		DISPOSITION				PARTMENT/		
Part No	o. D=	3065	5-6 578	5 }	Rework Scrap Use-as-is Work Order Update	4 I	Machining Sma moferming Fin	sstube all Fab nishing posite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
			,								· · · · · · · · · · · · · · · · · · ·
Root Cause	Date	Step	Qty	I.	ption of work order update or Non-conformance	Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training	Q.2-24 ×	160	Dx.	MACHI	CORNER MISSEN NE HOME SET TO FAR CEF. MAT'L.	0AS 16, 9-8, 057042 13/3/4	SURAP VESTRO XXX RECUTS Neces Curl solve		JM B-2-26	OAS 16 9-52 13/3/4	Q72 012 13/3/4
Unapproved						AULT CAT	TCORY .	0 /			<u> </u>
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in I	Tube Extrusio		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Grain Hardw Inspect Instruct Maint Mislat Offset Out of	tion Incomplete ctions Incomplete/Unclear cenance celecl		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw				Folio	 	le Dimensions				

Work Order ID 96184 *96184* Page 2 January-23-13 1:12:59 PM Item ID: D3065-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Step Leg *40* **Start Date:** 1/23/13 **Start Qty: 40.00 Cust Item ID:** Required Date: 2/22/13 Req'd Qty: 40.00 **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date: Stop Date: SPC (Y/N): Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. **Work Center ID** Qty Qty Number Stamp Description **Run Hours** Code 130 Chemical Conversion Coat per QSI005 4.1 0.00 *130* HandFinish 0.00 Memo Hand Finishing 140 Od - Inspect Part Finish 0.00 OC 0.00 Memo Quality Control

0.00

0.00

Identify as per dwg & Stock Location:

Memo

150

150
Packaging

Packaging

i.

NCR:	Yes /	No	WORK ORDER NO
	,		

	DQA:	Date:
RK ORDER NON-CONFORMANCE / UPDATE		

							***		QA Closed:	Date	:
Work Order	·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	ľ	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	1	ı	I	Danasi		Initial		ction	Sign &		
Root	0-4-	Chair			ption of work order update	1	i		Date	Verification	QC Inspector
Cause	Date	Step	Qty		or Non-conformance	Chief E	ig Desc	cription	Date	verification	QC ITISPECTOR
Doc/Data	_	ļ				}					
Equip/Tooling										`	
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Other				i							
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						AULI CA	TEGURT				
Landing					General Bend	Grai	_	_	Ovalized	Γ	Pressure/Forced
-	Bending			。 -	=	\vdash		-	Over/Under	tolorance	Temperature/Cure
-	Centre No	ot Concei	ntric to	U/S -	BOM/Route	\mapsto	ware	 	Part Incorre	F	Weld
-	Cracks	с : .		ļ	Broken/Damaged		ection Incomplete uctions Incomplete	/Uncloar	Part Lost/M	<u>}-</u>	Wrong Stock Pulled
_	Crushed/	Crimpea.		-	Burrs	\vdash	uctions incomplete ntenance	Junciear	Part Moved		Who hig Stock Fulled
-	Cuffs			-	Contamination	\vdash			Positioned \		
-	Heat Trea		T. da a	-	Countersink		abeled	-	Power Loss		Other
-	Inspectio	•	rube	<u> </u>	Cut Too Short	Misr			Trower ross)	Juige	Tottlet .
-	Ripples in			<u> </u>	Drill Holes	Offse					
<u> </u> -	Torque W			n	Drawing		of Calibration				
-	Turning S			<u> </u>	Finish	-	of Sequence				
<u> </u>	Wave/Tw	ist in Tul	be		Folio	Outs	ide Dimensions	····			

Work Ord				*961	84*							Page 3
tem ID: Revision ID:	D3065-5			Accept	*N9000	140	100)* 5	Setup	Start Stop	*NS	
item Name: Start Date: Required Dat Reference:	Step Leg 1/23/13 e: 2/22/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item ID Customer:	:				м	*NS	32 *
Approvals:		lan:	Date:	Tooling: SPC (Y/N):	Dat	e:]	Run	Start Stop	*NF	₹1* ₹2*
Sequence ID/ Work Center 160 *160*		Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
QC Quality Control		Memo		0.00					<i>,</i> ,	- / .	MF 13'	3-01

											DQA:	Date:	
NCR: \	/es	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE	•		•
									<u> </u>		QA Closed:	Date:	
)						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	er:		 			Dawe at l	1		دارنجا مرياه م	Crosstube	1	Water Jet	Engineering
Dort N	10				-	Rework		1	Skid-tube Machining	Small Fab	Bro	d. Eng. Coor.	Quality
Part N	VO.					Scrap Use-as-is	1	1	noferming	Finishing	4	e/Packaging	Other
NCR N	مام					Work Order Update	1		Large Fab	Composite	1 160/3101	Supplier	
Neitt	10.					Work order opdate	J		carge rab	composite	J	Supplie!	· .
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		·					ļ						
Operator							1						,
Material													
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Other													
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Training													
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Landi	ng (Gear				General	_	-	•		7	· 	1
	L	Bending			ļ	Bend	L	Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	-	Temperature/Cure
	L	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

January-23-13 1:12:59 PM

Work Order ID:

96184

Parent Item:

D3065-5

Parent Item Name:

Step Leg

Start Date: 1/23/13

Required Date: 2/22/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Pay: F. Now manufactured with 6061 T6 06 05 25 H M

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	292.0686	0.825	, 34.736844 ,9 .4736	- M	13.00	1.25
		J		Location		Loc Qty	<u>Lo</u>	c Code			•		
	a.	R#121572)	MAT021		292.068632							
		13 1873 18	`	117	285	0.248632							
			•	119	766	39.82							
				120	096	168.8							
				123	279	83.2			·	·			

				DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CO	ONFORM	MANCE / UPDATE		_	
				QA Closed:	Date:	
Work Order:	DISPOSITION	İ	AGAINST (DEPARTMENT,	/PROCESS	
work order.	Rework		Skid-tube Crosstube		Water Jet	Engineering
Part No.	Scrap	٨	Machining Small Fab		d. Eng. Coor.	Quality
	Use-as-is		oforming Finishing	Rec/Sto	re/Packaging	Other
NCR No.	Work Order Update		Large Fab Composite		Supplier	
Root Descri	ption of work order update	Initial	Action	Sign &		
Cause Date Step Qty o	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data						
Equip/Tooling					`	
Operator						
Material	·					
Setup						
Other		ļ				
Process		-	•	·		
Supplier	ļ					
Training	· ·					
Unapproved		LUT CATE	CORV	<u> </u>		<u> </u>
		ULT CATE	JURY			<u> </u>
Landing Gear	General	Grain	ſ	Ovalized	[Pressure/Forced
Bending Control Not Consentricto O/S	Bend BOM/Route	Hardwa	ro	Over/Under	tolerance	Temperature/Cure
Centre Not Concentric to O/S Cracks	Broken/Damaged		on Incomplete	Part Incorre	<u> </u>	Weld
Cracks Crushed/Crimped.	Burrs		ions Incomplete/Unclear	Part Lost/M		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	96184
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

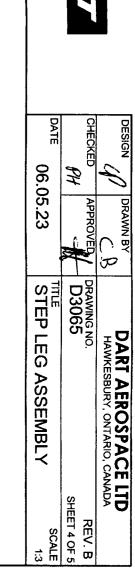
FIRST ARTICLE INSPECTION CHECKLIST

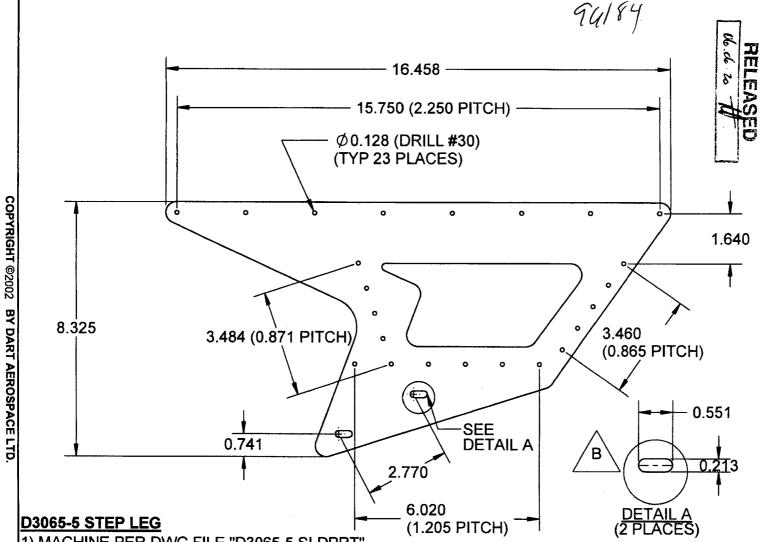
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	/		M.T	MM-02 "" "TKM-01 ""
15.750	+/-0.005	15.750	V		M.T	// 11
2.250	+/-0.005	2.248	J		ver	JKM-01
3.460	+/-0.005	3.457	V		vers	// "
0.865	+/-0.005	0.865			var	
6.020	+/-0.005	6.017	V		ver	+
1.205	+/-0.005	1.202			ver	11
3.484	+/-0.005	3.485	V		ver	1/
0.871	+/-0.005	0.868	/		ver	11 \(\cdot\)
8.325	+/-0.010	P. 335	V		Herry	Blod-N-J-02 TKM-01
0.551	+/-0.010	0.550	/		Ver	JKM-01
0.213	+0.005/-0.000	0.213			veen	// 11
Ø0.128	+0.005/-0.000	0./28	<i>\</i>		vern vern	ע (ו

Measured by:	what	Audited by:	Prototype Approval:	N/A
Date:	13.02.25	Date: 3/3/4	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM LA	21
С	06.06.23	Dwg Rev. changed	KJ/JLM	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\





1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

ÖR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1) BREAK ALL SHARP EDGES 0.005 TO 0.010) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED) ALL DIMENSIONS ARE IN INCHES